

# Work Order ID 74034

Tuesday, September 20, 2011 3:07:20 PM



Item ID: D3492-13

Accept



Setup Start



Revision ID:

Item Name: Plug

Stop



Start Date: 9/20/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 9/23/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3492

D

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Turn as per Folio FA715 & Dwg D3492

Dwg Rev:

Folio Rev:

Handwritten: 11/19/30

Handwritten: 30

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

Handwritten: 11/19/30

Handwritten: 30

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Handwritten: 11/09/30

Handwritten: 30

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Item ID: D3492-13

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Item Name: Plug

Start Date: 9/20/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 9/23/2011 Req'd Qty: 30.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00



Small Fab

0.00

Small Fab

Memo

Small Fab

1-Debur

*[Handwritten signature]*

11/9/30

30

*[Handwritten mark]*

140

0.00



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

*[Handwritten signature]*

150

0.00



Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

Hand Finishing

30XØ m-f 11/10/04

# Work Order ID 74034

Tuesday, September 20, 2011 3:07:20 PM



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Item ID: D3492-13	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Plug					
Start Date: 9/20/2011	Start Qty: 30.00		Cust Item ID:		
Required Date: 9/23/2011	Req'd Qty: 30.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
-----	--	------	--	--	--	--	--	--	--



Powdercoat  
Powder Coating

Memo  
(Flat End Only)  
START TIME: 11:45  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 12:15

30X Ø M- / 11/10/06

170	QC3- Inspect Part Finish	0.00							
-----	--------------------------	------	--	--	--	--	--	--	--



QC  
Quality Control

Memo 0.00

30 BR 11-10-06

180	Identify as per dwg & Stock Location: F-PB	0.00							
-----	--	------	--	--	--	--	--	--	--



Packaging  
Packaging

Memo 0.00

30X Ø M- / 11/10/06

**Work Order ID 74034**

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Tuesday, September 20, 2011 3:07:20 PM

Item ID: D3492-13

Accept



Setup Start



Revision ID:

Stop



Item Name: Plug

Start Date: 9/20/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 9/23/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

MF  
11-10-07

# Picklist Print

Tuesday, September 20, 2011 3:07:17 PM

Page 1

Work Order ID: 74034

Parent Item: D3492-13

Parent Item Name: Plug



Start Date: 9/20/2011

Required Date: 9/23/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev:A 11.04.19 per dwg revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6R0.750 Purchased

No

100

f

32.1530

0.05

1.578947



6061-T6 Round Bar .750"



100V30

Location

Loc Qty

Loc Code

MAT013

32.153

112442

0.796

116406

0.617

117481

12.76

118106

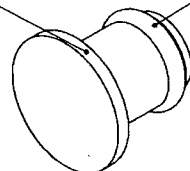
17.98

1.77A



D3492-XX PLUG  
(SEE TABLE)

NAS1611 O-RING  
(SEE TABLE)



### D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
	1					1	NAS1611-012	O-RING
							NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING

#### NOTES:

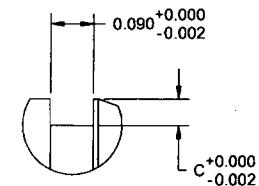
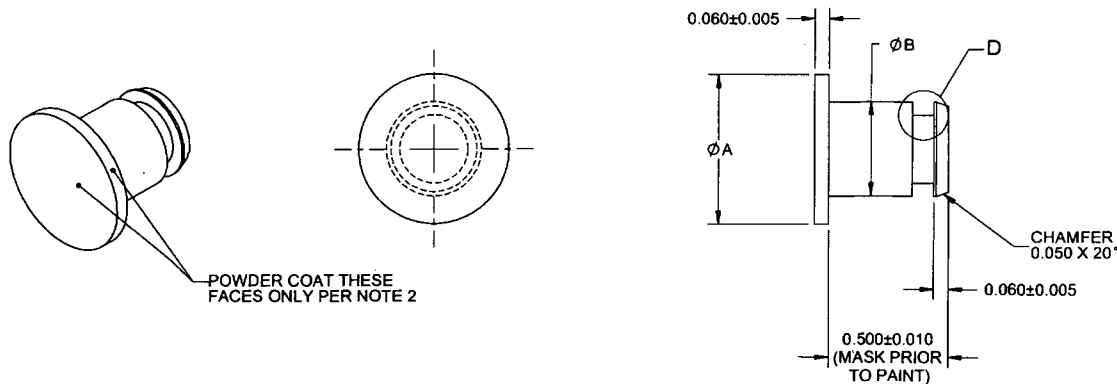
1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

WLO 711034

RELEASED  
2011-05-30

D	INCORPORATED DEO D3492-C-1. SHT 2 DIM C FOR -1 WAS 0.055. (SEE CAR11-048)	AJS	11.05.24
C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.	J.F.	D3492	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PLUG	2:1
DATE	11.05.24	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



**DETAIL D**

**D3492-XX PLUG**

**D3492-XX PLUG MACHINING DETAILS**

P/N	A	B	C	MATERIAL SPEC	
D3492-1	0.625	0.394	0.050	M6061T6R0.625	△
D3492-3	0.750	0.582	0.045	M6061T6R0.750	
D3492-5	0.375	0.188	0.045	M6061T6R0.375	
D3492-7	0.500	0.270	0.045	M6061T6R0.500	
D3492-9	0.938	0.750	0.045	M6061T6R1.000	
D3492-11	0.850	0.664	0.045	M6061T6R0.875	
D3492-13	0.750	0.510	0.045	M6061T6R0.750	△

761034

**NOTES:**

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

**RELEASED**  
2011-05-30

DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.	JFS	<b>D3492</b>	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		<b>PLUG</b>	4:1
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8 7 6 5 4 3 2 1